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PRELIMINARY ISSUE

D3849-047
Job Sheet 200457

Accounting Job SE19-646-017



POSITIVE RECALL

SEP 11 2019 21

RELEASED DATE

Part No: D3849-047

Job Qty: 4 pcs

Part Name: Fwd Heavy-Duty Wearplate, Float Skid Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/11/19

Job Tracking No:

Due Date: 9/27/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: DWG REV F IPP RevA: New issue DD verified by: EC IPP Rev: B 12.09.11 AS PER DWG REV D DD
VERF: JLM IPP Rev: C 14.11.26 AS PER DWG REV E DD VERF: JLM IPP Rev: D 16.06.17 DWG REV F DD
VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	1 pcs	9/27/19	9/27/19	0.00	1.52	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	1 pcs	9/27/19	9/27/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	1 pcs	9/27/19	9/27/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140 Small Fab - 2 - B4B	1 pcs	9/27/19	0.00	0.25	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
150 QC 5	1 pcs	9/27/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160 Packaging 3-1 - Stock - B4B	1 pcs	9/27/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - (Weld per dwg A/R S.S. rod Batch: 11027501) - Weld D3901-041 bar to wearplate as per dwg D3849

Descriptions: 120 - (QC9- Inspect visual per QSI004- Fusion Welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Small Fab) 1- Apply a layer of TEXTURE COATING as per dwg

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____) LOCATION : FG002

170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3849-7	Plate	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	
D3901-041	Wearbar Weldment	1 pcs (1 ea)	110-Large Fab - Welded Assy-1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D3849-7	1	3	0
	D3901-041	1	6	0

Part Specifications	
Specifications could not be found.	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

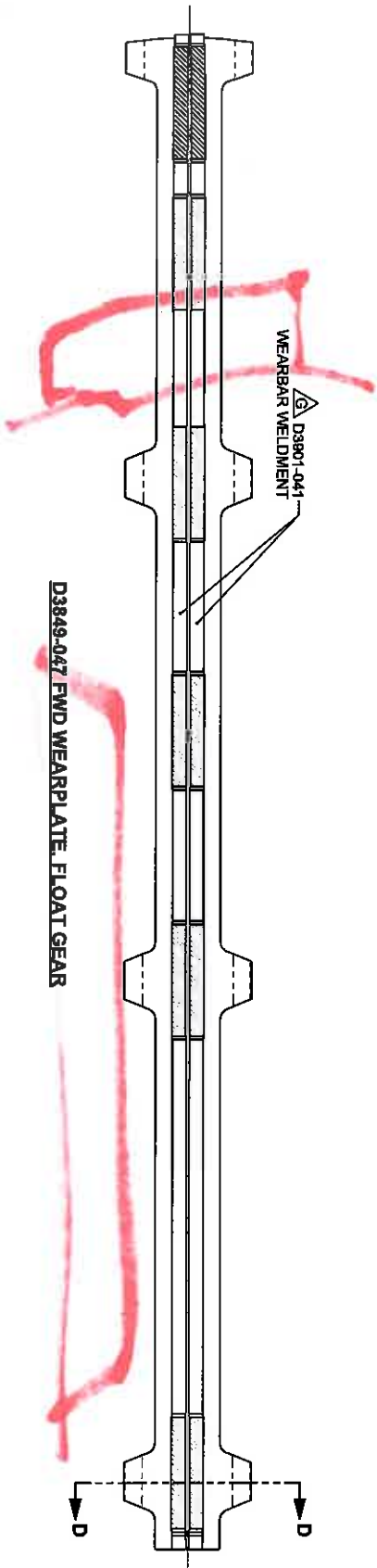
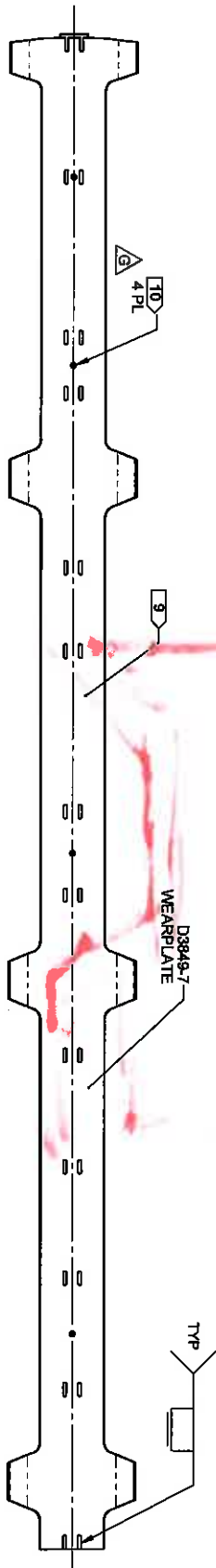
NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS														
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐								
Date :	Sequence #:	QTY Affected :		MRB (QS1042)															
Description Work Order Deviation				Disposition															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY															
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
				Completed By _____															
				Lead hand / Supervisor _____															
QC / QA Coordinator _____																			

QTY	P/N	DESCRIPTION
1	D3849-047	FWD WEARPLATE, FLOAT GEAR
2	D3901-041	WEARBAR WELDMENT



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 7.45 lbs
 - 8) WELDING: PER QSI 004
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.8.
 - 10) TRANSFER DRILL $\varnothing$ 0.188 HOLES FROM D3849-7 WEARPLATE TO D3901-041 WEARBAR, AFTER APPLYING TEXTURED COATING

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	ZF	HILLSBORO, OR
CHECKED	SAD	REV. 03
MFG. APPR.	DD	SHEET 5 OF 10
APPROVED		SCALE
DE APPR.		NTS
DATE	19.06.11	

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